

Date: Thursday, 12/14/2006 3:39:30 PM  
 User: Kim.Johnston

## Process Sheet

Customer	CU-DAR001, Dart Helicopters Services	Drawing Name	: 204 SKIDTUBE "I" BEAM
Job Number	: 29961	Part Number	: D2597
Estimate Number	: 10996	Drawing Number	: D2597 REV D
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 12/14/2006	Drawing Revision	: D
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 1/10/2007
Previous Run	: 29675	Qty:	5
Written By	: <i>AT 06.12.15</i>	Um:	Each
Checked & Approved By			
Comment	: Est: D 96.10.15 Eliminated DEO, Changed Dwg Revision KS		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D25003100	Ext'n - 'I' Beam Web 4"
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Extrusion "I" Beam Web 4"	
	Pick; Qty : Part Number Description Batch	<i>35751 AT/JB 06-12-18</i>
1.	D2500-3-100 Extrusion	
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
		
	Comment: LANDING GEAR RESOURCE 1 Cut D2500-3 to length: 84.25" Use Jig DT8094 to drill pilot holes. Open to 0.625 diameter using a uni-bit.	<i>AT/JB 06-12-18 (5)</i>
3.0	QC5	INSPECT WORK TO CURRENT STEP
		
	Comment: INSPECT WORK TO CURRENT STEP	<i>AT 06-12-18 (5)</i>
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
	Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1	<i>AT/JB 06-12-18 (5)</i>
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	<i>AT 06-12-18 (5)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/12/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 204 SKIDTUBE "I" BEAM

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: *PL*

*JD 06-12-18 (5)*

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*JD 06-12-18 (5)*

Job Completion



*U do 12-18*

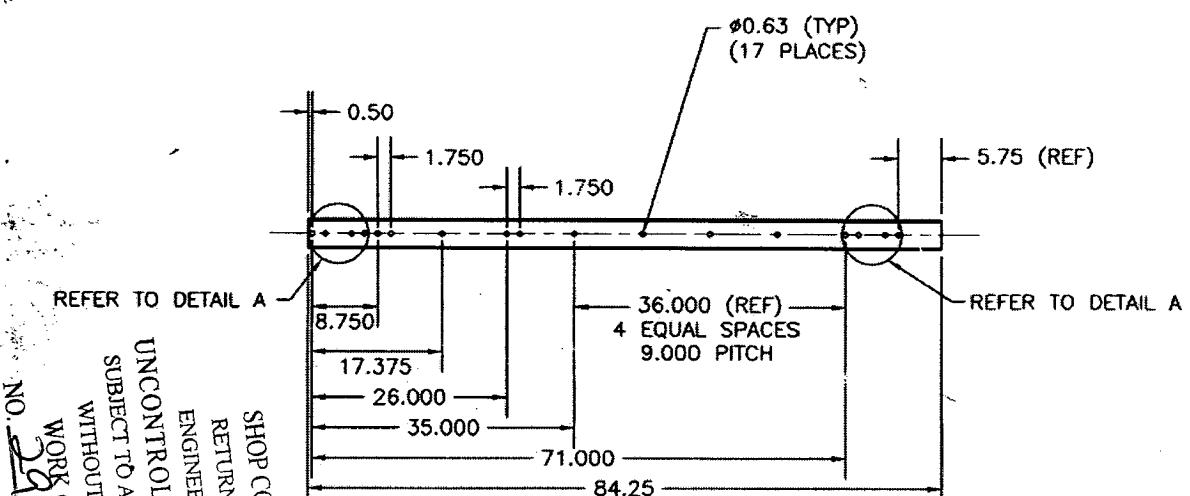
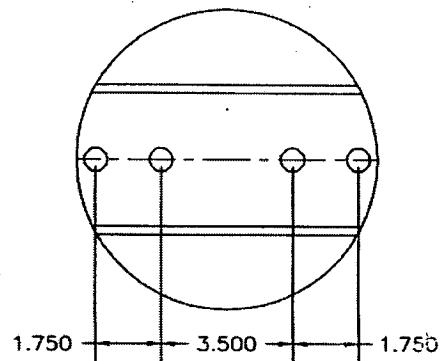
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A  
SCALE 5:24



REFER TO DETAIL A  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26961

MANUFACTURED FROM D2500-3 EXTRUSION  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
48917 DS

DO NOT COPY OR REPRODUCE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. D	
D2597		D2597	SHEET 1 OF 1	
DATE	TITLE			SCALE
98.09.14	204 WEB			1:24
A	96.09.16	NEW ISSUE		
B	96.10.29	5.75 WAS 0.50		
C	97.07.23	0.63 WAS 0.56		
D	98.09.14	INCORPORATED DEO 9097		

